

Work Order ID 78057

December-28-11 10:12:45 AM

78057

Page 1

Item ID: D412-785-003-401

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Pax Speaker Mount, Aft

Stop ***NS2***

Start Date: 28/12/2011 Start Qty: 4.00

4

Cust Item ID:

Required Date: 05/01/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 11/12/28 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D412-785-003-101

B

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

11-12-29

(4)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

11-12-29

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

11/12/29

(24)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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N900040100Setup Start ***NS1***

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Stop ***NS2***

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Start Date: 28/12/2011 Start Qty: 4.00

4

Cust Item ID:

Required Date: 05/01/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab								
Small Fab	<i>Memo</i> <i>e'sink as per dwg</i> <i>W/A</i>	0.00							
Small Fab	<i>CE 12.01.03</i>								
150		0.00							
150	QC5- Inspect part completeness to step on W/O								
QC	<i>Memo</i>	0.00							
Quality Control									
160		0.00							
160	Chemical Conversion Coat per QSI005 4.1								
HandFinish	<i>Memo</i>	0.00							
Hand Finishing	<i>1/12 12-01-05</i>					<i>4</i>			

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Work Order ID 78057***78057***

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Required Date: 05/01/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC3- Inspect Part Finish	0.00							
170									
QC	Memo	0.00							
Quality Control									
180	Identify as per dwg & Stock Location: _____	0.00							
180									
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

MF 12-01-05

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Picklist Print

December-28-11 10:12:49 AM

Page 1

Work Order ID: 78057

78057

Parent Item: D412-785-003-401

D412-785-003-401

Parent Item Name: Pax Speaker Mount, Aft

Start Date: 28/12/2011

Required Date: 05/01/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 11-09-01 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.040

Purchased

No

sf

31.3184

2.105263

M2024T3S 040

**

B11-12-29

2024-T3 .040 sheet

Location

Loc Qty

Loc Code

MAT022

31.318421

117684

31.318421

117684

4

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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

C

B

A

TRANSFER DRILL 4X Ø0.203 HOLE FROM
D412-785-003-201/-203 SPEAKER MOUNT TO AIRFRAME
TRANSFER DRILL 8X Ø0.098 HOLES FROM
MS21069L3 ANCHOR NUTS (CENTERED ON
PREVIOUSLY DRILLED HOLES) TO AIRFRAME
COUNTERSINK 8X Ø0.179 X 100°
ATTACH MS21069L3 ANCHOR NUTS USING
MS20426AD3-4 RIVETS
ATTACH D412-785-003-201/-203 SPEAKER
MOUNTS USING AN525-10R7 TO MS21069L3
ANCHOR NUTS
6 PLACES TYP

PASSENGER ADDRESS SPEAKER
ATTACH USING MS27039-806

ITEM NO.	QTY. -101	PART NO.	DESCRIPTION
1	4	D412-785-003-201	SPEAKER MOUNT
2	2	D412-785-003-203	SPEAKER MOUNT
3	6	TR650-Cxi	SPEAKER
4	24	AN525-10R7	SCREW
5	24	MS27039-806	SCREW
6	24	MS21069L3	ANCHOR NUT

STG
REF
ENG
UNCONT
SUBJECT

WIP
WIP
NO 78057 M.C.J
11/12/128

D412-785-003-101 PASSENGER SPEAKER MOUNT INSTALLATION

D412-785-003-201
SPEAKER MOUNT AFT SHOWN
4 PL
D412-785-003-203
SPEAKER MOUNT FORWARD SIMILAR
2 PL

CABIN ROOF
REF

SPEAKERS MOUNTED
IN LIGHTENING HOLES
AT THESE LOCATIONS

STN 84

STN 110

STN 139

BL +36

BL 0.0

BL -36

D412-785-003-203
2 PL

D412-785-003-201
2 PL

D412-785-003-201
2 PL

RELEASED
2010-08-20

B	UPDATE FOR LSTC	HS	09.10.09
A	NEW ISSUE	HS	08.12.10
REV.	DESCRIPTION	BY	DATE
DESIGN	RN	EAGLE COPTERS MAINTENANCE	
DRAWN		CALGARY, ALBERTA, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	D412-785-003-101	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.	N/A	PAX SPKR MOUNT	NTS
DATE	09.10.09	COPYRIGHT © 2008 BY EAGLE COPTERS MAINTENANCE THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM EAGLE COPTERS MAINTENANCE LTD.	

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

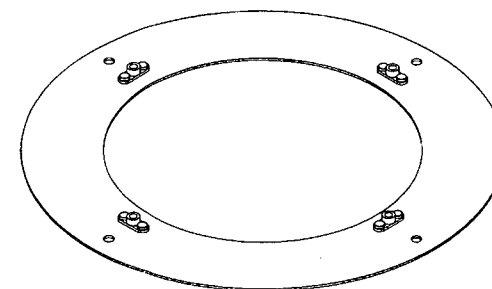
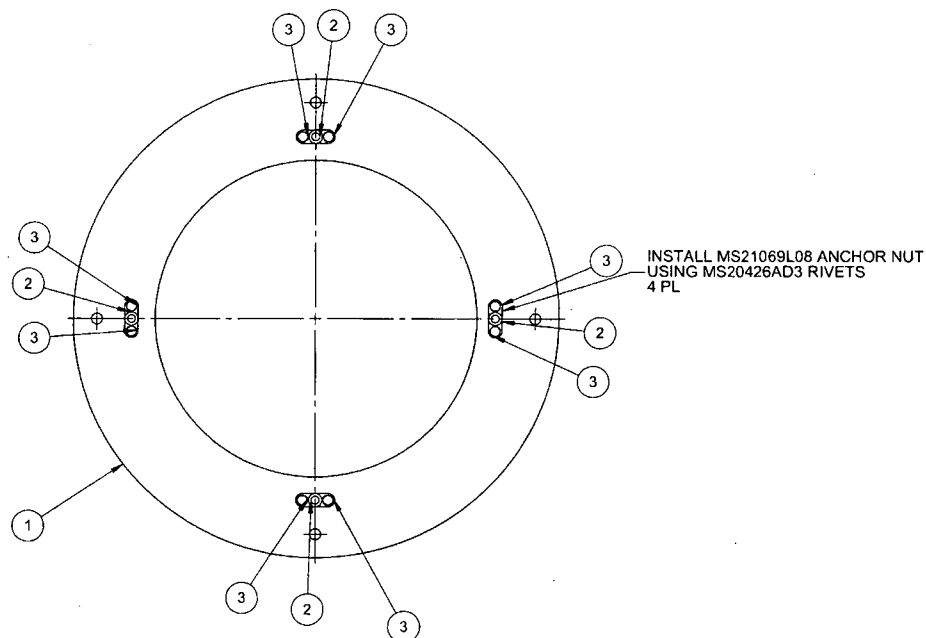
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

78057

ITEM NO.	QTY. -201	PART NUMBER	DESCRIPTION
1	1	D412-785-003-401	PAX SPKR MOUNT, AFT
2	4	MS21069L08	ANCHOR NUT
3	8	MS20426AD3-4	RIVET



D412-785-003-201 PAX SPEAKER MOUNT AFT

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 5) IDENTIFICATION: IDENTIFY WITH DART P/N D412-785-003-201 USING FINE POINT PERMANENT INK MARKER
- 6) WEIGHT: 0.13 lbs

RELEASED
2010-08-25

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MFG. APPR.	N/A	D412-785-003-101	SHEET 2 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	N/A	PAX SPKR MOUNT	NTS
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

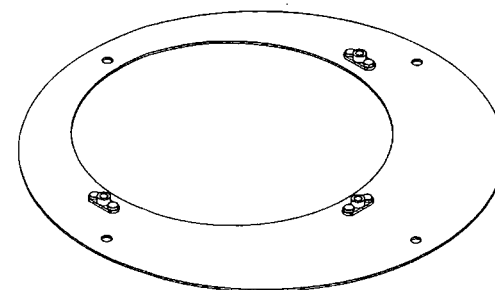
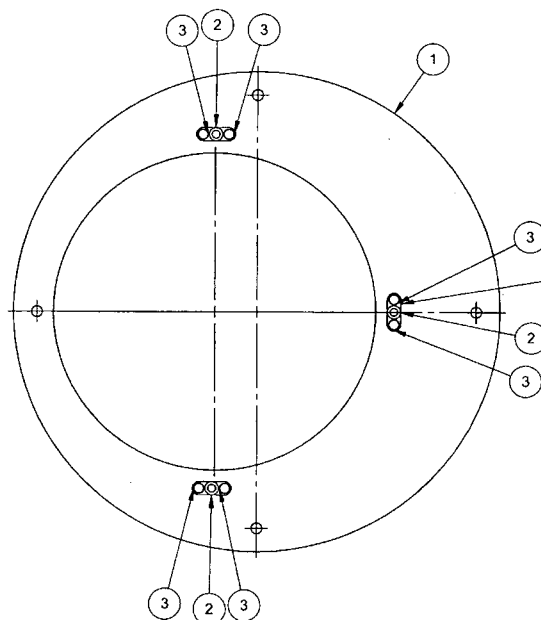
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NOTE: Date & initial all entries

78057

ITEM NO.	QTY. -203	PART NUMBER	DESCRIPTION
1	1	D412-785-003-403	SPEAKER MOUNT, FWD
2	3	MS21069L08	ANCHOR NUT
3	6	MS20426AD3-4	RIVET



D412-785-003-203 PAX SPEAKER MOUNT FWD

RELEASED
2010-08-25

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 5) IDENTIFICATION: IDENTIFY WITH DART P/N "D412-785-003-203 USING FINE POINT PERMANENT INK MARKER
- 6) WEIGHT: 0.05 lbs

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MFG. APPR.	N/A	D412-785-003-101	SHEET 3 OF 5
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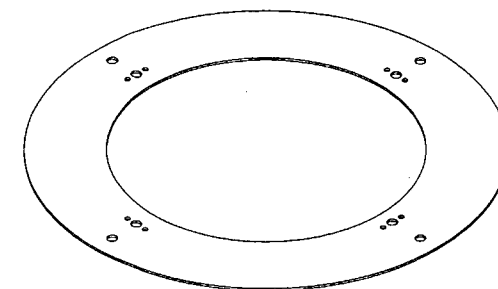
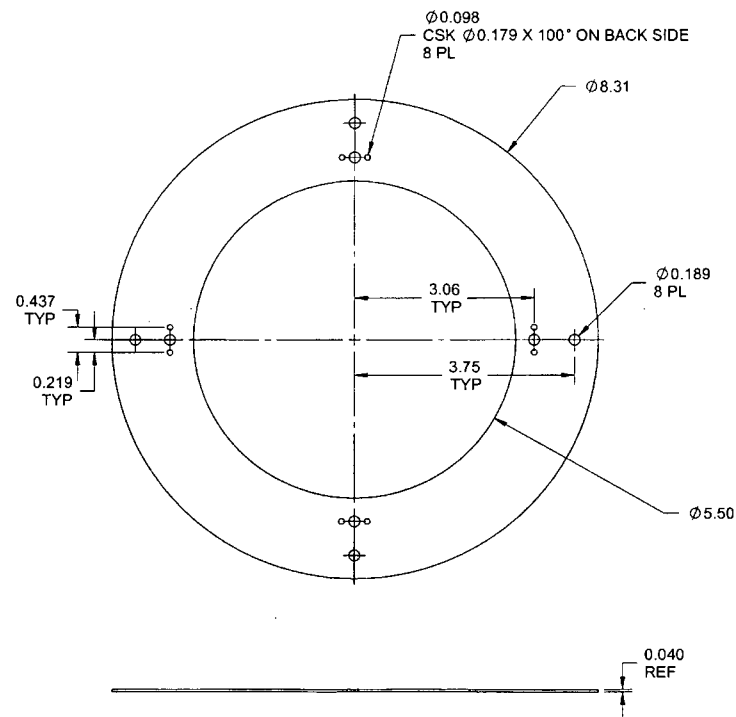
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NOTE: Date & initial all entries

78057



D412-785-003-401 PAX SPEAKER MOUNT AFT

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.040 THICK
PER AMS-QQ-A-250/4 OR AMS 4037
- 2) FINISH: ALODINE, PRIME AND PAINT PER BHT-412-MM
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 5) IDENTIFICATION: N/A
- 7) WEIGHT: 0.12 lbs

RELEASED
2010-08-25

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	N/A	D412-785-003-101	SHEET 4 OF 5
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DE APPR.	N/A	PAX SPKR MOUNT	NTS
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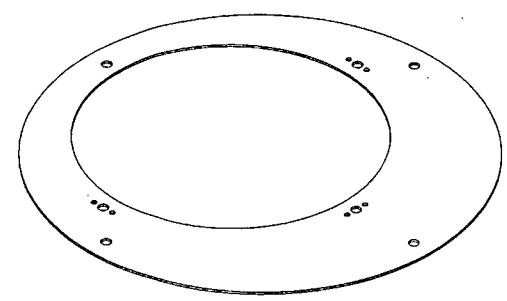
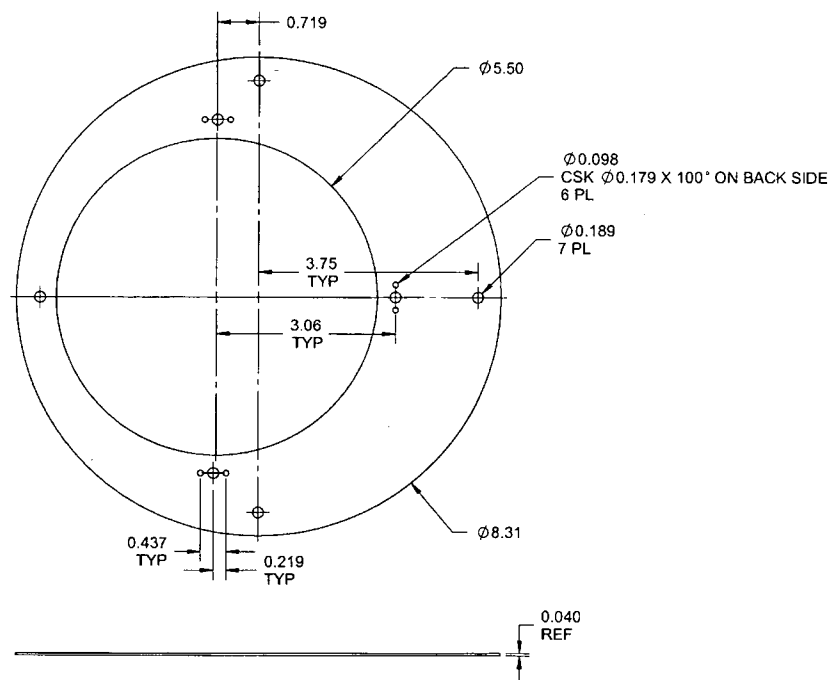
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D412-785-003-403 PAX SPEAKER MOUNT FWD

RELEASED
2010-08-25

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.040 THICK
PER AMS-QQ-A-250/4 OR AMS 4037
- 2) FINISH: ALODINE, PRIME AND PAINT PER BHT-412-MM
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 5) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

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